
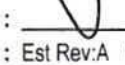


Date: Tuesday, 29/06/2007 10:53:48 AM
 User: Linda Lacelle

Process Sheet

Split 20406-11

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32710-2
 Estimate Number : 10808
 P.O. Number : N/A
 This Issue : 29/05/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 32328
 Written By : 
 Checked & Approved By : 
 Comment : Est Rev:A 03.01.27 New issue KJ/RF

Drawing Name : STRUT ASSEMBLY
 Part Number : D3180041
 Drawing Number : D3180-PRELIMINARY
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 01/06/2007

Qty: 3
 4-Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 3.7625 f(s)/Unit Total : 3.7625 f(s)
 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall
 (M304TR0.750W0.049)
 Batch: M104565

45-180
 43-180

FF 07-05-29

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313
 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180

FF 07-05-29

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.203" as per Dwg D3180

FF 07-05-30

2-Bend one side only as per Dwg D3180 Identify as D3180-1

FF 07-05-31

3-Deburr edges

FF 07-05-30

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
 APPROVAL

10705-30

POSITIVE
 RECALL

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 32710

Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



(P70) 3

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-05-31

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/06/04

7.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2022-101 Spacer B30543

8.0

D26906

Lanyard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2690-6 Lanyard M28519

② 31191

9.0

A1449

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3180-1(ref) Strut B32710

1 A1449 Grommet M1487

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M104118

7/6/4 59

Tuesday, 29/05/2007 10:53:48 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 32710

Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

BLRS001

Pip Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 BLRS-001 Pip Pin

M15608

12.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3)

M103691

13.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-10 Screw

18836

7/6/4 SQ

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

FF 07-06-04

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 32710

Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



P10

1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

~~FOR ENGINEERING USE ONLY~~

R

7/4/11 SG

17.0

QC21

FINAL INSPECTION/W/O RELEASE



1

Comment: FINAL INSPECTION/W/O RELEASE

2010/6/11

Job Completion



W 07-06-11

OK TO MANUFACTURE UP TO STEP 15
Do not PASS STEP 15.

POSITIVE RECALL

EFFECTIVE *07/06/11* AUTH *4*

RELEASED *07/06/11* DATE *1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-11	160	split w/o for a qty of 1 to ship to a customer.	J	07-06-11	1	J 07-06-11	J 07-06-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries